

STOCK.

Work Order ID 136064

136064

Page 1

Item ID: D205-523-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 9/17/2015 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: SH Date: 2015 09 02 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9301	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file & type labels as per PPP D205-523-013, CHG 002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 15-09-03 (2)

DAS

38

9-89

SEP 08 2015

DAS

6

9-89

SEP 02 2015

DAS

27

9-89

DAS

38

9-89

SEP 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Picklist Print

August 27, 2015 2:40:58 PM

Page 1

Work Order ID: 136064

136064

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015

Required Date: 9/17/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B02.04.04 Updated Drawing and Added Inspection Level 21SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-523-043		Manufactured	No			110	Each	2.0000	1	2		DAS 6 9-89	27 27 9-89
D205-523-043									**				

Slide Bar Assembly

DAS
38
9-89

Location

Loc Qty

Loc Code

ST374

2

114929

2

2

D2224

Manufactured No

110

Each

13.0000

1

2

DAS
6
9-89

~~27~~
27
9-89

D2224

Rappel Anchor Assembly

DAS
38
9-89

Location

Loc Qty

Loc Code

ST479

13

114998

1

123383

6

123801

1

126418

5

2

D2229

Manufactured No

110

Each

20.0000

2

4

D2229

Doubler

DAS
38
9-89

Location

Loc Qty

Loc Code

ST004

20

110094

2

112921

18

2
2

SEP 03 2015
DAS
6
9-89

~~27~~
27
9-89

Picklist Print

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Page 3

Work Order ID: 136064

136064

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015

Required Date: 9/17/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0563J

Purchased

No

110

Each

1,029.000

8

16

NAS1149D0563.J

Washer

DAS
38
9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

801

m130799

63

m132035

55

~~m132256~~

83

m132677

600

ST269

156

m128257

156

ST271

19

m131026

19

DAS
6
9-89
27
9-89

SEP 03 2015

17
7X



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

20150827

SH 1360 64

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>D. Shepherd</i>	_____
D. SHEPHERD (DE # 02)	
DATE:	05.05.11
CERT. NO.:	SH96-90
ISSUE NO.:	3

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4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

5. PARTS LIST

-013	-043	Part No.	Description
X		D205-523-013	HELI-RAPPEL™ INSTALLATION
1	X	D205-523-043	SLIDE BAR ASSEMBLY
	1	D3011-1	RAPPEL SLIDE BAR
	2	33116	STUD FITTING
	2	MS21042L6	NUT (OR MS21042-6)
	2	AN960JD616	WASHER
	2	D3012-1	DECAL
	2	D3012-3	DECAL
	2	D3012-5	DECAL
1		D2224	RAPPEL ANCHOR
2		D2229	DOUBLER
4		AN5-14A	BOLT
8		AN960JD516	WASHER
4		MS21042L5	NUT (OR MS21042-5)